

Date: Wednesday, 5/31/2006 7:36:30 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 27289	
Estimate Number : 11376	
P.O. Number : N/A	Part Number : D33872
This Issue : 5/31/2006 S.O. No. : N/A	Drawing Number : D3387 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 27143	Material : N/A
Written By : <u>See LA COMMENT Below</u>	Due Date : 6/15/2006
Checked & Approved By : <u>06.05.31</u>	Qty: 6 Um: Each
Comment : Est:A 05.06.10 New Issue KJ/JLM Est:B 06.03.22 Split c'sink op. EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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Comment: Qty.: 1.5680 f(s)/Unit Total: 9.4078 f(s)
 6061-T6 Bar .50" x 6.0"
 Material: 6061-T6/T651 (QQ-A-200/8)
 (M6061T6B0.500x06.000)
 Identify for D3387-2
 Batch: M101092 / 4 pcs

M100817 / 1 pcs

M180311 / 1 pcs

J.F. 06/06/06 (6)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blank: 6.000" x 0.500" x 17.800" long

J.F. 06/06/06 (6)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA512 and Dwg D3387
 Identify as D3387-2
 Tumble and Deburr NO sharp edges

J.F. 06/06/06 6

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 C'sink Ø0.375" as per Dwg D3387

J.G. 06/06/06 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/06/08

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 5/31/2006 7:36:30 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 27289

Part Number: D33872

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/06/06

6

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SL 06/06/07

6

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST72*

Al 06/06/07

6

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Step 06/06/08

6

Job Completion



W 06.06.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	27289
Description: Arm		Part Number:	D3387-2
Inspection Dwg: D3387 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	0.503	✓			
7.577	+/-0.010	7.570	✓			
R0.030	+/-0.010	R0.030	✓			
Ø0.191	+0.005/-0.000	Ø0.192	✓			
1.700	+/-0.010	1.701	✓			
0.188	+/-0.010	0.195	✓			
11.405	+/-0.010	11.405	✓			
Ø0.507	+0.000/-0.001	Ø0.507	✓			
2.033	+/-0.005	2.031	✓			
R0.300	+/-0.010	R0.300	✓			
1.000	+/-0.005	1.000	✓			
2.000	+/-0.010	2.002	✓			
1.347	+/-0.005	1.347	✓			
0.250	+/-0.010	0.250	✓			
R0.125	+/-0.010	R0.125	✓			
0.125	+/-0.005	0.134	✓			
R0.032	+/-0.010	R0.032	✓			
Ø0.375 x100°	+/-0.010					
0.500	+/-0.010	0.498	✓			
0.300	+/-0.010	0.306	✓			

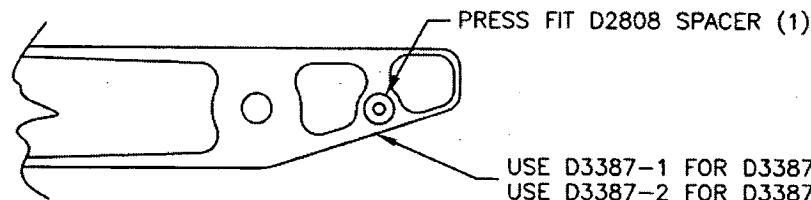
Measured by:	<i>mf</i>	Audited by:	J.F	Prototype Approval:	N/A
Date:	06/06/06	Date:	06/06/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue	KJ/JLM	<i>[Signature]</i>



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3387	REV. A
DATE 05.01.18	TITLE ARM	SHEET 1 OF 1	SCALE 1:3
A	05.01.18	NEW ISSUE	

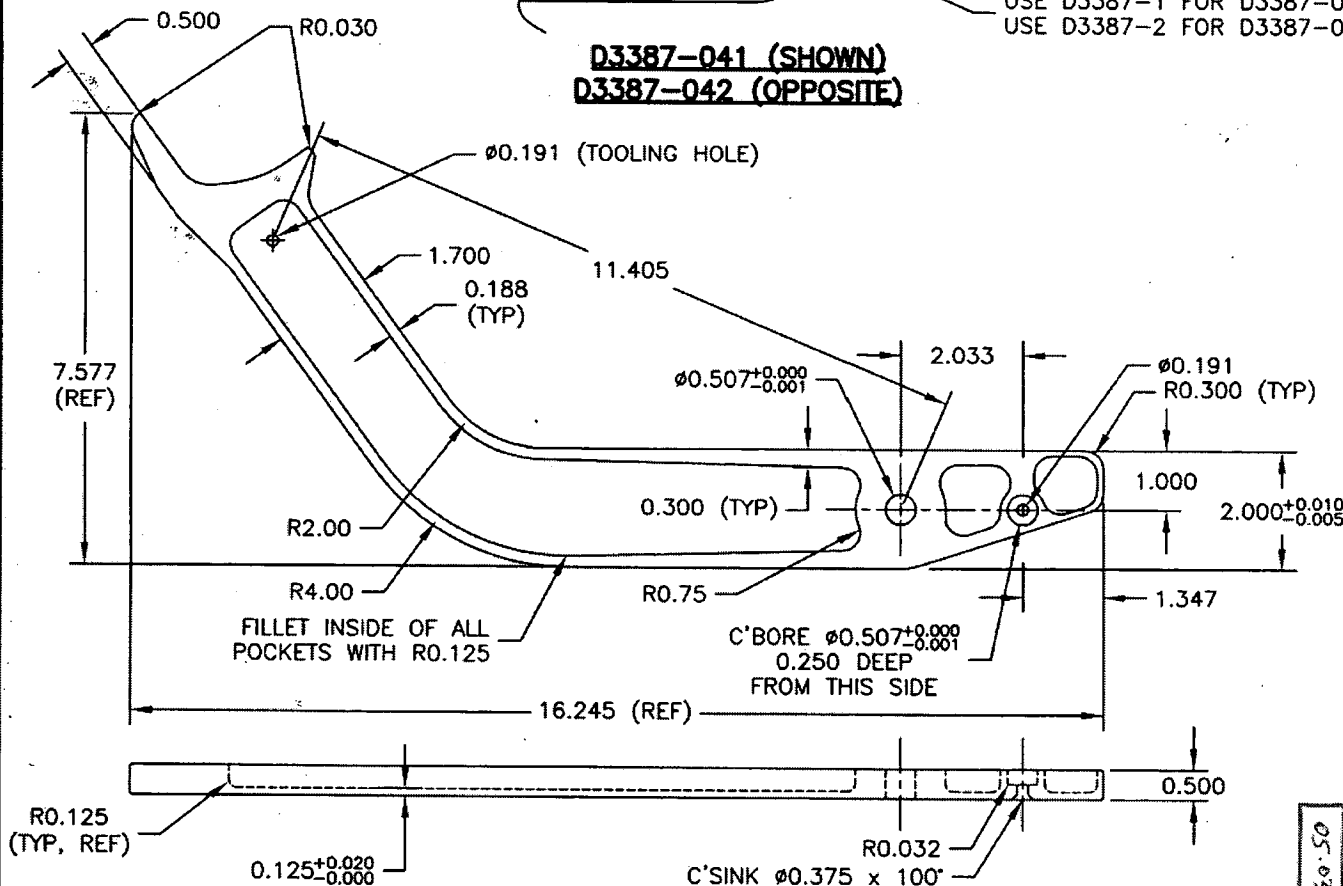
RELEASED
05.03.11



PRESS FIT D2808 SPACER (1)

USE D3387-1 FOR D3387-041
USE D3387-2 FOR D3387-042

D3387-041 (SHOWN)
D3387-042 (OPPOSITE)



D3387-1 (SHOWN)
D3387-2 (OPPOSITE)

GENERAL NOTES

- 1) MACHINE PER DRAWING FILE "D3387-A.DWG"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11) 0.500 THICK (REF DART SPEC. M6061T6B0.500)
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

ENGINEERING

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WITHOUT NOTICE

WORK ORDER
NO. 22289